	Work Order ID 68372 Fuesday, April 12, 2011 11:51:40 AM										
Revision ID: Item Name:	D3190-1 Chafing Shield 4/12/2011 4/15/2011	Start Qty: 10.00 Reg'd Qty: 10.00		Accept	Cust Item I			S	Setup Stai	(=	
Reference: Approvals:	Process Plan			Tooling: _	Da	ate:		F	Run Sta		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3190		sion Nbr		ALIANDA A	edi nococcon			**************************************			
Waterjet FLOW CNC Waterjet		Memo CUT AS PE DWG REV: PROG REV		0.00				<u> </u>	11 <u>-4-18</u>	(14))
QC Quality Control		QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00				<u>B</u>	1-4-18		-
106		QC8- Inspect parts - seco	and check	0.00 كرراد	ગ્ <u>ન</u> (૧૭			(H)	<u> </u>		

Quality Control

W/O:	<u>-</u>		VORK ORDER CHANG	ES				<u> </u>	
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<i>2</i>							
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	۸:	Date:	
	R	esolution:	Disposit	ion:	_ QA: N/C CI	osed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section B			ation	Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
		·							

Tuesday, April 12, 2011 11:51:40 AM



Page 2

Item ID:

D3190-1

Accept



Setup Start



Revision ID:

Start Date:

Chafing Shield Item Name:

Required Date: 4/15/2011

Start Oty: 10.00 4/12/2011

Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Tool ID

Start Run

QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Reject

Oty

Stop

Insp.

Sequence ID/

Work Center ID

107

Small Fab

Small Fab

Operation Description

SHEAR

Memo

Memo

Memo

Roll as per Dwg D3190

Set Up/ **Run Hours**

0.00

0.00

Sp 1164/19

Accept

Qty

Stamp Number

Reject

110

Quality Control

QC5- Inspect part completeness to step on W/O

0,00 S WO4/70

120

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

37 11.04-5

W/O:			WO	RK ORDER CHANG	ES				5
DATE	STEP	PR	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	Part No: PAR		Fault Cate	_ NCR: Yes	Date: _				
	Res	olution:	Disposition	n:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC	nitial	Corrective Action Sect Action Description	ion B		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date		tion C	Chief Eng	QC Inspector
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Work Order ID 68372

Page 3

Tuesday, April 12, 2011 11:51:40 AM

Item ID:

D3190-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Chafing Shield

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Tool ID

Reference:

Process Plan:

Date:

Tooling:

Date:

Start

Approvals:

QC:

Date:

SPC (Y/N):

Date:

Stop

Run

Sequence ID/

Work Center ID

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

Tool # Plan

Accept Code Qty

Reject Qty

Reject Insp.

130

Memo

0.00

0.00

Number Stamp

Quality Control

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W/O:	VO: WORK ORDER CH				ES					•
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	esolution:	Disposit	ion:	_ QA: N/0	Clos	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (N	CR)				
DATE	CTED	Description of NC	Corrective Action Section			gn &	Verific	cation	Approval	Approval
DATE	SIEP	STEP Section A		Initial Action Descriptio Chief Eng Chief Eng			Section C		Chief Eng	QC Inspector
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						•				

Picklist Print

Tuesday, April 12, 2011 11:51:47 AM

Work Order ID: 68372

Parent Item: D3190-1

Parent Item Name: Chafing Shield

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A□03.05.26□New issue□KJ/RF□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA	MILL BEST IN COST	Purchased	No		And American controls.	100	sf	32.0000	0.2153	2.266316		3,	
										121	1-4-18	•	

304/316 .020" Sheet

<u>Location</u>	Loc Qty	Loc Code		Circ
MAT20	32	•		(14)
117285	32		11778	

Page 1

W/O:		***************************************	GES		•			2			
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	•Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:	Fault Category: NCR: Yes No DC					DQA: Date:			
	R	esolution:	Disposition) :	QA: I	VC CIo	sed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC Corrective Action			ction B	Sign &	Verific	cation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Initial Action Description Chief Eng Chief Eng			Section C		Chief Eng	QC Inspector	
				,							

DART AEROSPACE LTD	Work Order:	48372
Description: Chafing Shield	Part Number:	D3190-1
Inspection Dwg: D3190 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.25	+/-0.030	9.750	x		PLO WJOZ	•
3.13	+/-0.030	3,(31	7		V 1807	
0.020	+/-0.010	1097	8		V	
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				v		
				w		
-						
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Measured by:	B	Audited by:		Preliminary Approval:	
Date:	11-4-19	Date:		Date:	

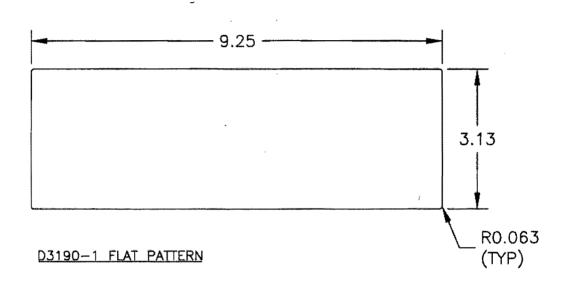
Rev	Date	Change	Revise	i by	Approved
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W/O: WORK ORDER CHANGES													
DATE	STEP	PRO	CEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No		PAR #:	Fault Cate	Fault Category: NCR: Yes No					DQA: Date:				
	R	esolution:	Disposition	on:	QA: N/C	Clos	ed:		Date: _				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)	_			·			
DATE	STEP	Description of NC	Corrective Action Section		0	Verific		Approval	Approval				
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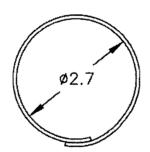


i	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
	CHECKED!	APPROVED	DRAWING NO.	REV. A				
	9	Ar	D3190	SHEET 1 OF 1				
	DATE		TITLE	SCALE				
	03.05.16		CHAFING SHIELD	1:2				
	A	03.05.16	NEW ISSUE					



SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 48372

p/11-04-12



D3190-1 ROLLING DETAIL NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:			W	ORK ORDER CHAN	IGES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	egory:	NCI	R: Yes	No DQ	4:	Date:	
	R	solution: Disposition:				QA: N/C Closed: Date:				
NCR:		1	WORK ORD	ER NON-CONFOR	MANCE	(NCR)			
DATE	CTED	Description of NC		Corrective Action Section B			Verific	ication	Approval	Approval
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
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